

Date: Wednesday, 29/04/2009 3:00:36 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 47595
 Estimate Number : 10250
 P.O. Number :
 This Issue : 29/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2053 **BK**
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D2053 REVC
 Previous Run : 38531 Project Number : N/A
 Material :
 Due Date : 10/05/2009 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JUD 09.04.29
 Comment : Est D 02.03.18 Added Rev.B NG (Issue this IPP with part number D2052)
 Est Rev:E now water jet 07-10-25 DD
 Est Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S090 5052-H32 .090 Sheet



Comment: Qty.: 0.0404 sf(s)/Unit Total : 0.8085 sf(s)
 Material: 5052-H32, 0.090" Thick
 (M5052H3S.090)
 Batch: 100782 **AB 9-5-26**

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2053
 Dwg Rev: E **AB 9-5-26**
 Prog Rev: E
 ****grain direction along 1.987" ****
 2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47595

Part Number: D2053

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2053 using CNC Brake

SP 09/05/27

(22)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/27 counter (X22)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005

ump 09/05/27 (X22)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref 4.3.5.8) as per QSI 005 4.3

START TIME: 3:15pm

OVEN TEMPERATURE: 320°C

FINISH TIME: 3:45pm

of 09-05-22

(X22)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09/05/28 (22)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST9

FL 09/05/28 (22)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/28

Job Completion



MF 09-05-28

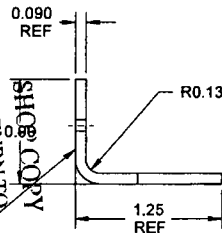
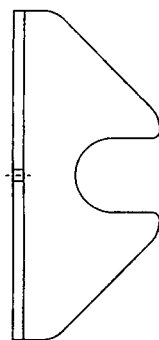
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

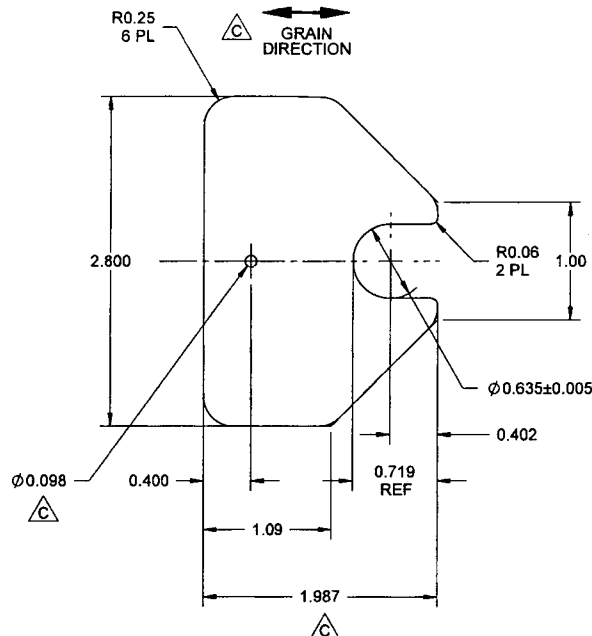
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

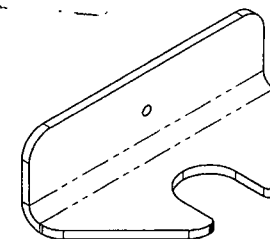
NOTE: Date & initial all entries



D2053 BRACKET



D2053F FLAT PATTERN



NO. 1588
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOCK COPY

- NOTES:
- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR -T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 \triangle POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2053" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH \triangle
 - 7) WEIGHT: 0.04 lbs \triangle

RELEASED
08-05-13/11

C	1.987 WAS 1.979 (ZN B5-1); ADD WEIGHT (ZN A8-1); ADD IDENTIFICATION (ZN A4-1); ADD Ø 0.098 HOLE FOR POWDER COAT MOUNTING (ZN B6-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDTEX (ZN A6-1); ADD 6061-T6 MATERIAL OPTION (ZN A5-1); ADD GRAIN DIRECTION (ZN D5-1); QTY (2) Ø 0.213 MOUNTING HOLES REMOVED; REASON: PRODUCT IMPROVEMENT	PH	08.04.25
B	Ø 0.635 WAS Ø 0.437, 0.635 WAS 0.325	DS	02.03.12
A	NEW ISSUE	DS	92.01.12
REV.	DESCRIPTION	BY	DATE
DESIGN	\triangle		
DRAWN	\triangle		
CHECKED	\triangle		
MFG. APPR.	\triangle		
APPROVED	\triangle		
DE APPR.	\triangle		
DATE	08.04.25		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.	D2053	REV. C	
TITLE	BRACKET	SCALE	NTS
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